

Date: Tuesday, 08/04/2008 4:54:56 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEB		
Job Number	: 38464			Part Number	: D2739		
Estimate Number	: 10498			Drawing Number	: D2739 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 08/04/2008 S.O. No. :			Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LANDING GEAR			Due Date	: 28/04/2008 Qty: 4 Um: Each		
Previous Run	: 38175						
Written By	:						
Checked & Approved By	: <u>JD 08.4.09</u>						
Comment	: Est Rev: C 02.11.28 Reformat KJ						
	Est Rev: D 06-03-21 As Per Rev C JLM						
	Est Rev: E 07-07-28 As per Rev D JLM Verified By:						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D26005108	Extrusion 'I Beam' thin	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion 'I Beam' thin	
		Pick: Qty Part Number Description Batch	<i>JD 8-4-21</i>
		1 D2600-5 Web <u>B29985</u>	
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2739.	
		2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739	<i>JD 8-4-21</i>
		3-Use uni-bit to open holes to finish size as per Dwg D2739.	
		4-Bevel Fwd end of extrusion and Deburr holes and ends.	
		5-Dburr	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<i>JD 8-4-21</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

4.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JD 8-4-21 (4)

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

3T 08-04-22

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: Skid tube cell

2T 08-04-22

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/23 (4)

Job Completion



UMF 08-04-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>PH</i>	APPROVED <i>AN</i>	DRAWING NO. D2739
DATE 07.05.29		TITLE WEB
		SCALE 1:15
		REV. D SHEET 1 OF 1

RELEASED
07-20-98